

54350 DREV

Work Order ID 53490

November 6, 2009 8:44:27 AM



Page 1

Item ID: D3798-041

Revision ID: *X B*

Item Name: Spacepod Floor

Start Date: 06/11/2009 Start Qty: 4.00

Required Date: 13/11/2009 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan: *PL*

Date: *09-11-18*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3798

B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3798-1

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

6061

.000

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

template D3798-1T1

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

template D3798-1T1

27 Sorulic

not NOT PULLED

B 9-11-18

B 9-11-18

(Signature)

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Page 2

Item ID: D3798-041

Accept



Setup Start



Revision ID: *X B3*

Stop



Item Name: Spacepod Floor

Start Date: 06/11/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

0.00



Small Fab

Memo

0.00

Small Fab

1- C'sink as per dwg D3798-1

2- Deburr if necessary

9509/11/25 *(4)*

140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

27808/11/26

(04)

(44)

150

0.00



HandFinish

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

Hand Finishing

BR 09-11-26

(4)

Work Order ID 53490

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Page 3

Item ID: D3798-041

Accept

Revision ID: *XB 4*

Item Name: Spacepod Floor

Start Date: 06/11/2009 Start Qty: 4.00

Required Date: 13/11/2009 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Setup Start

Stop

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

=> 11/09/11/26

(X4)

Ø

170



Small Fab

Small Fab

Memo

1- Assemble D3798-1 to D3798-5 as per dwg

0.00

0.00

09/12/07

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

=> 8 or 12/07

(X4)

Work Order ID 53490

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Page 4

Item ID: D3798-041

Revision ID: A

Item Name: Spacepod Floor

Start Date: 06/11/2009 Start Qty: 4.00

Required Date: 13/11/2009 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

m/09091

Memo

POWDER COAT

Start Time: *1:05*

Oven Temperature: *320°*

Finish Time: *1:35*

0.00

0.00

09-12-8

4

200



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

09/12/08

4

8

210



Small Fab

Small Fab

QC3- Inspect Part Finish

Memo

1-Install foam as per dwg D3798 using contact cement

A/R Contact Cement batch: *112983*

2- Trim foam if necessary

0.00

0.00

09-12-11
09-12-12

Work Order ID 53490

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Page 5

Item ID: D3798-041

Accept



Setup Start

Revision ID: *AB*

Stop



Item Name: Spacepod Floor

Start Date: 06/11/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

2012/11

Quality Control



230

Identify as per dwg & Stock Location *241B*

0.00



Packaging

Memo

0.00

Packaging

9/12/11

240

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*09/12/14**09/12/11*

Picklist Print

November 6, 2009 8:44:32 AM

Page 1

Work Order ID: 53490

Parent Item: D3798-041RevA

Parent Item Name: Spacepod Floor

Comments:

Start Date: 06/11/2009

Required Date: 13/11/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M6061T6S.050

Purchased

No

100

sf

36.5753

37.0274

34



6061-T6 .050 Sheet

B9-17-18

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

36.57523158

110791

34.5715

112567

0.00373158

17349

2

D3798-3RevA

Manufactured

No

170

Each

3.0000

4.0000



Spacepod Floor Foam

13189 x1 = 9.2568

11287 x3 = 27.706

EC 09-12-11

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

51098

3

D3798-5

Manufactured

No

170

Each

4.0000

4.0000



Reinforcement

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

GA

4

52807

4

B53904

09/12/07
B53899

2

Picklist Print

Page 2

November 6, 2009 8:44:32 AM

Work Order ID: 53490

Parent Item: D3798-041 Rev K

Parent Item Name: Spacepod Floor

Comments:

Start Date: 06/11/2009

Required Date: 13/11/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20426AD434		Purchased	No			210	Each	3,030.000	132.0000			



Rivet

MP
09/12/07

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

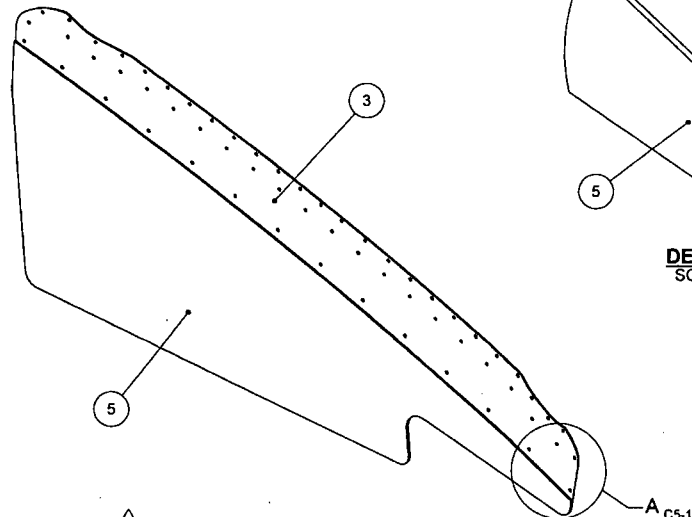
3030

113064

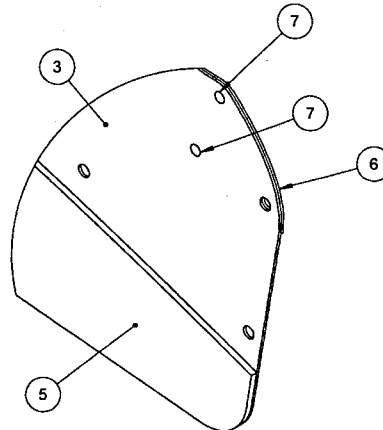
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EP 09/12/07
M15541

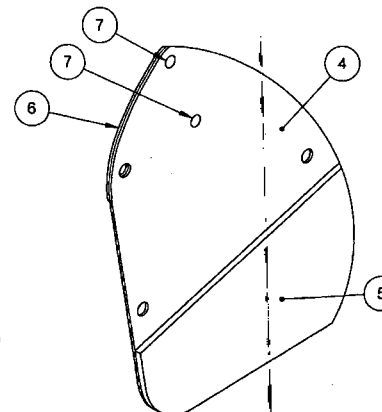
ITEM NO.	QTY. -041	QTY. -042	PART NUMBER	DESCRIPTION
1	X		D3798-041	SPACEPOD FLOOR ASSEMBLY, LH
2		X	D3798-042	SPACEPOD FLOOR ASSEMBLY, RH
3	1		D3798-1	SPACEPOD FLOOR
4		1	D3798-2	SPACEPOD FLOOR
5	1	1	D3798-3	SPACEPOD FLOOR FOAM
6	1	1	D3798-5	REINFORCEMENT
7	33	33	MS20426AD4-3	RIVET



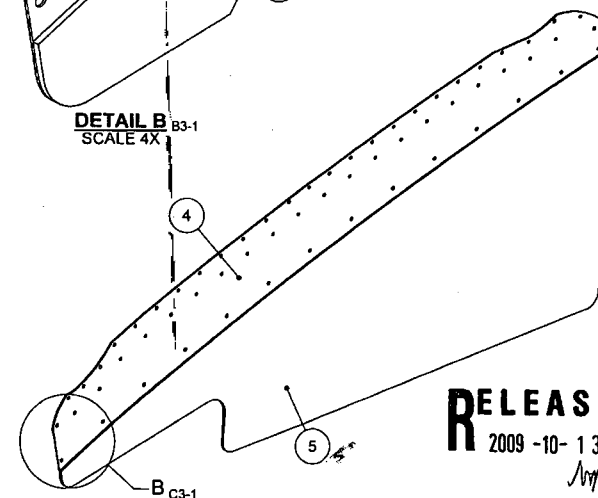
B D3798-041 SPACEPOD FLOOR, LH



DETAIL A
A6-1
SCALE 4X



DETAIL B
B3-1
SCALE 4X



B D3798-042 SPACEPOD FLOOR, RH

SHOP COPY
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53490
B/C 04-11-6

RELEASED
2009-10-13

NOTES:

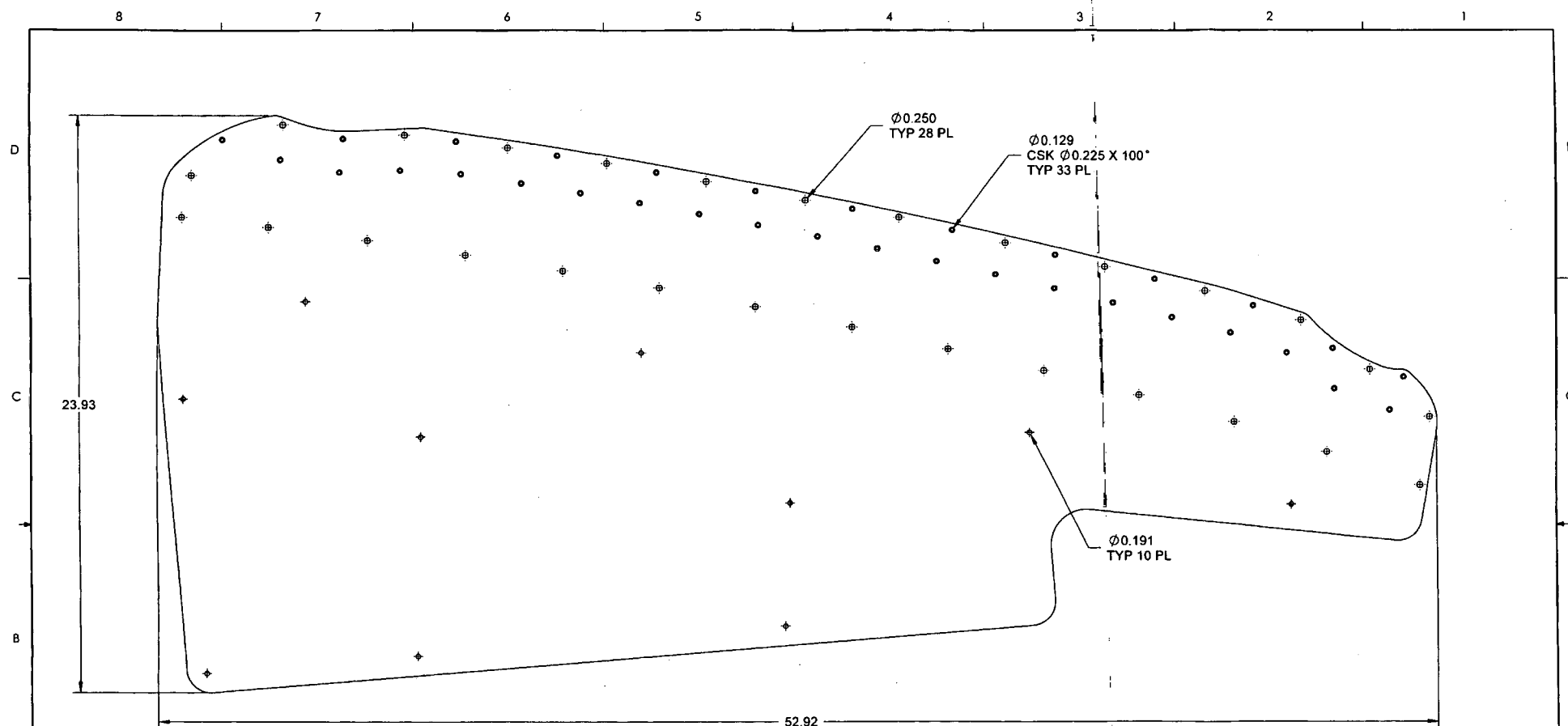
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3798-041/-042 USING WHITE FINE POINT PERMANENT MARKER
- 7) WEIGHT: D3798-041 - 5.0 lbs
D3798-042 - 5.0 lbs

B 8) ASSEMBLY INSTRUCTIONS

- RIVET D3798-5 REINFORCEMENT TO D3798-1/-2 SPACEPOD FLOOR USING RIVETS AS INDICATED
- POWDER COAT PER NOTE 2
- INSTALL D3798-3 FOAM AS INDICATED USING CONTACT CEMENT. TRIM TO FIT.

B	ADD -5 (SHEET 4); REVISE -041/-042; ADD ASSEMBLY INSTRUCTIONS (NOTE 8)	HS	09.10.08
A	NEW ISSUE	HS	08.10.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.10.08		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3798	REV. B SHEET 1 OF 5
TITLE SPACEPOD FLOOR	SCALE NTS
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D3798-1 SPACEPOD FLOOR

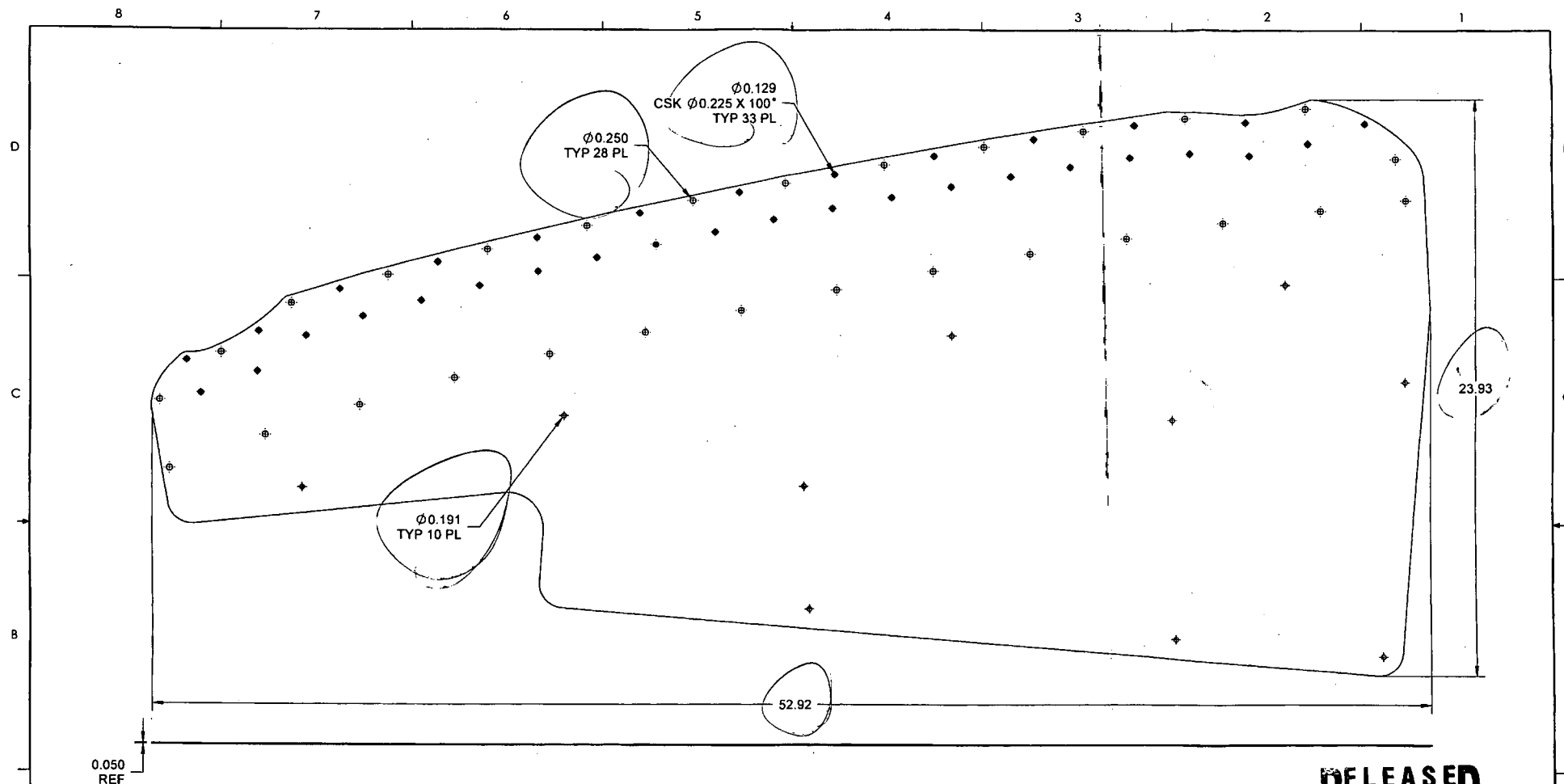
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.0 lbs
- 8) CONTROL PART PER TEMPLATE DT9432

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DE APPR.		REV. B SHEET 2 OF 5
DATE	09.10.08	

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2009-10-13

W/0 53490



D3798-2 SPACEPOD FLOOR

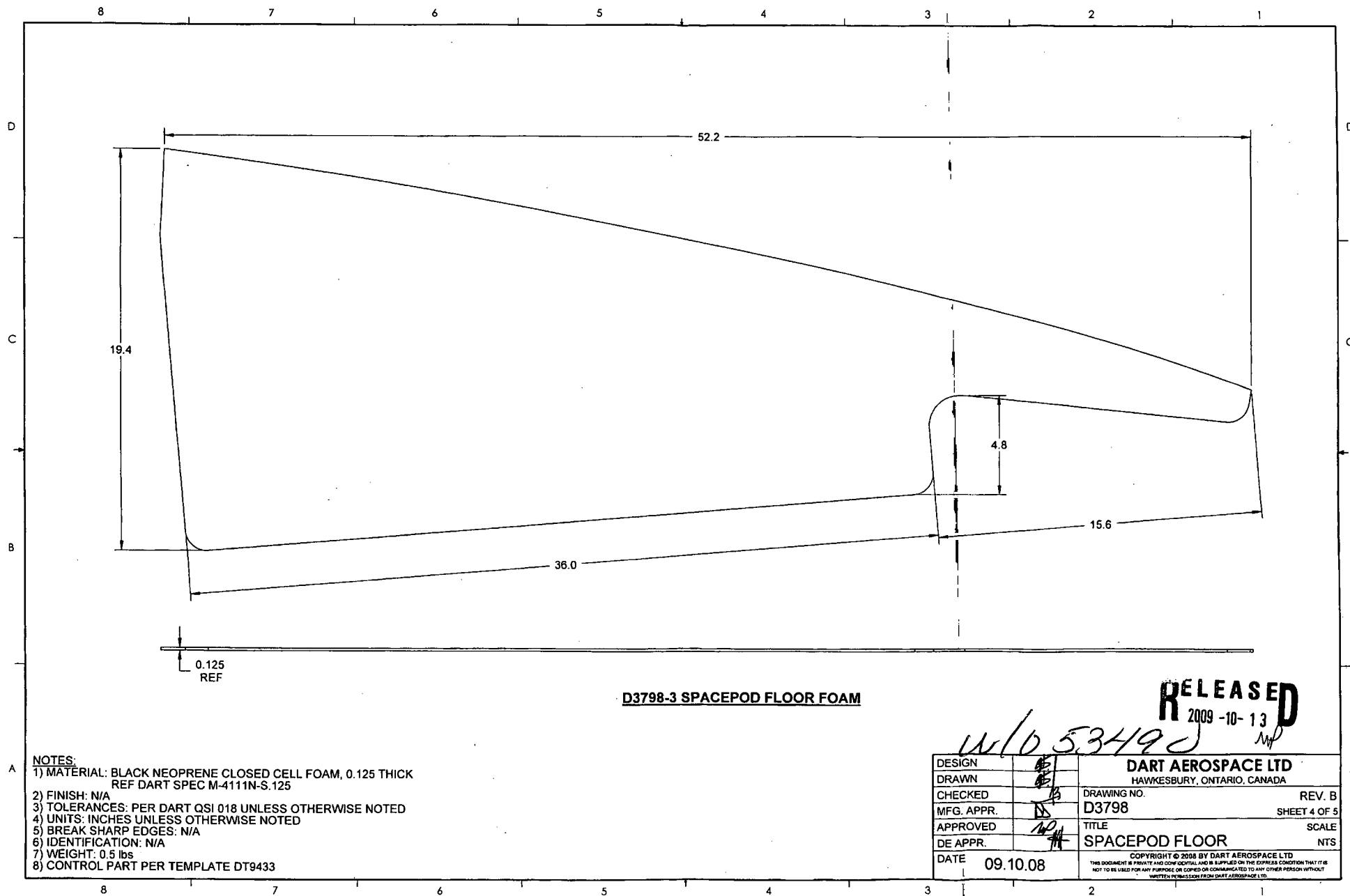
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.0 lbs
- 8) CONTROL PART PER TEMPLATE DT9432

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2009-10-13

W/0 53490

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DE APPR.		
DATE	09.10.08	



D3798-3 SPACEPOD FLOOR FOAM

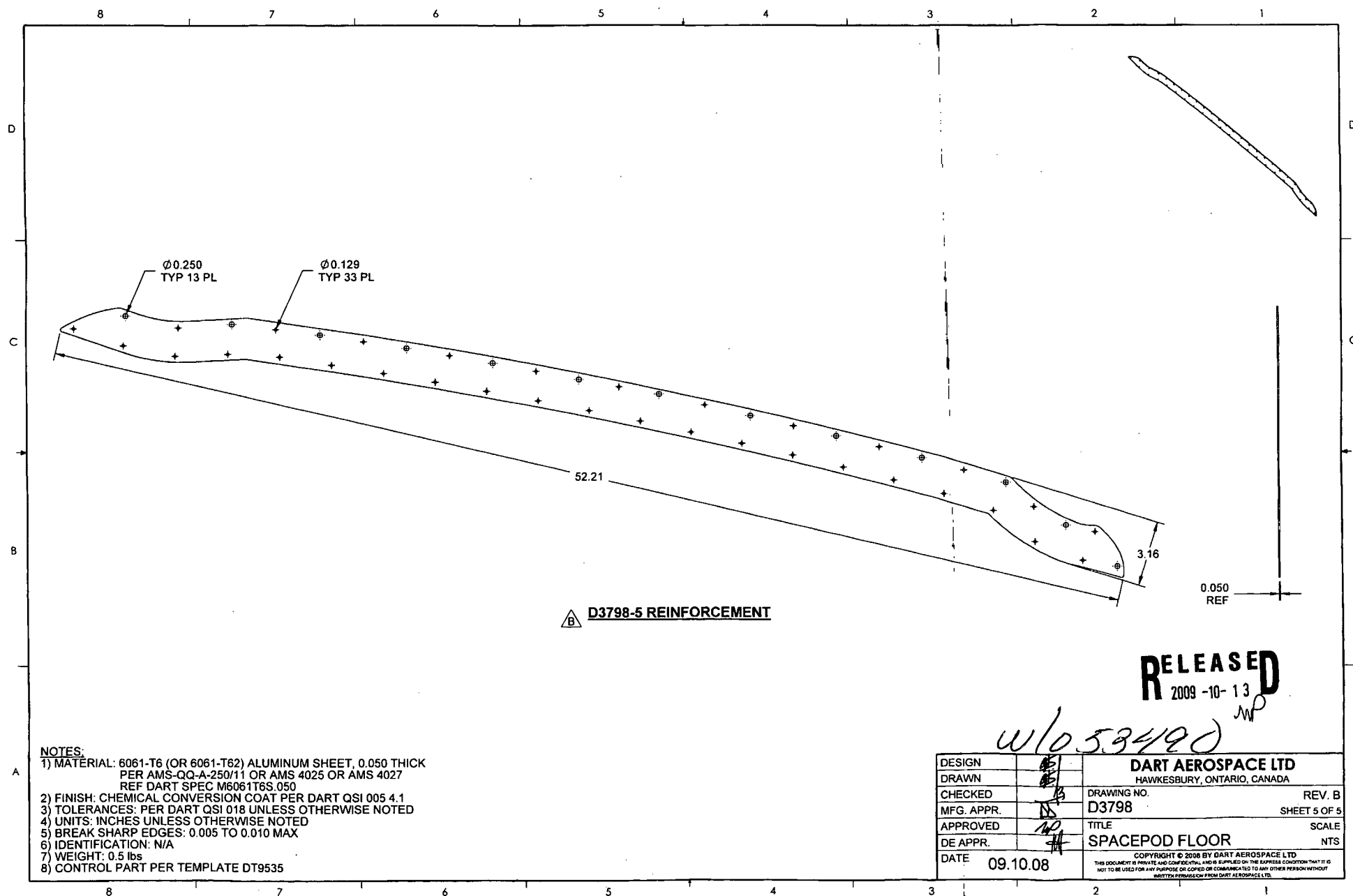
- NOTES:**
- 1) MATERIAL: BLACK NEOPRENE CLOSED CELL FOAM, 0.125 THICK
REF DART SPEC M-4111N-S.125
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.5 lbs
 - 8) CONTROL PART PER TEMPLATE DT9433

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2009-10-13

W/053490

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3798 TITLE SPACEPOD FLOOR REV. B SHEET 4 OF 5 SCALE NTS
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DATE	09.10.08	

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NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.5 lbs
- 8) CONTROL PART PER TEMPLATE DT9535

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DE APPR.		REV. B SHEET 5 OF 5
DATE	09.10.08	

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2009-10-13